

Date: Friday, 25/04/2008 12:51:52 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MIRROR ARM		
Job Number	: 38795			Part Number	: D2010103		
Estimate Number	: 10505			Drawing Number	: D2010 REV. C2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/04/2008 S.O. No. :			Drawing Revision	: C2		
Prsht Rev.	: NC			Material	:		
First Issue	: 25/04/2008 Type : SMALL /MED FAB			Due Date	: 05/05/2008 Qty: 10 Um: Each		
Previous Run	: 37438			KJ/RF			
Written By	:			Comment	: Est: F 02.08.21 Re-format; Added D2057		
Checked & Approved By	: <u>JDP 08-4-25</u>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.5750 f(s)/Unit Total : 15.7500 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall (M304TR0500W035)	Batch No: M 107403 ⑥ M 107164 ④
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727 Identify as D2010-103	SB 08/04/2008 ⑩
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Bend as per Dwg D2010 using bending Jig D2010-103T2 2- Deburr	FF 08-05-01 ⑩
4.0	D2057	Plug	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Plug Pick: Qty Part Number Description Batch	FF 08-05-01 ⑩
		1 D2057 Plug B 34366	FF 08-05-01 ⑩
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-flare before installing plug as per dwg D2010	FF 08-05-01 ⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

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Job Number:



Seq. #: Machine Or Operation:

Description :

2-Install D2057 plug as per Dwg D2010

FF 08-05-01 (10)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-05-01 (10)

7.0 POWDER COATING

POWDER COATING



M100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00AM

11 08-05-02

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-A

08/05/02

10X

9.0 PACKAGING 1

PACKAGING RESOURCE #



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 281

BB

SO

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/02

Job Completion



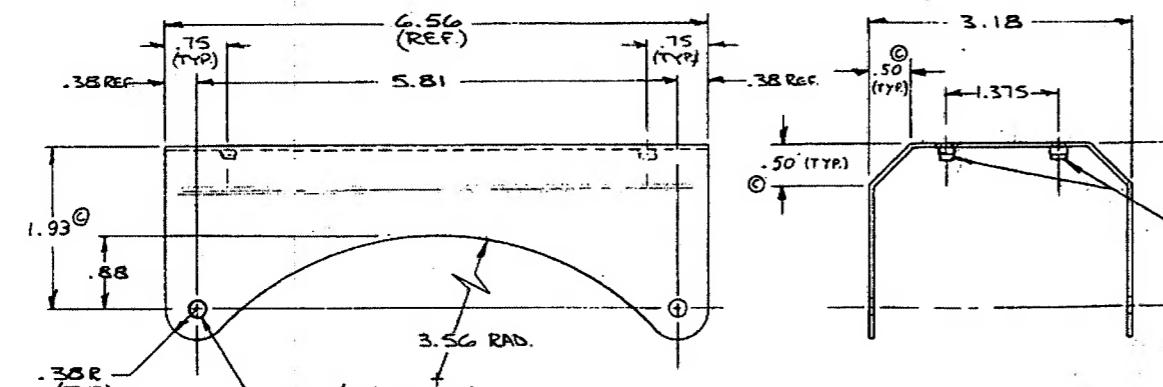
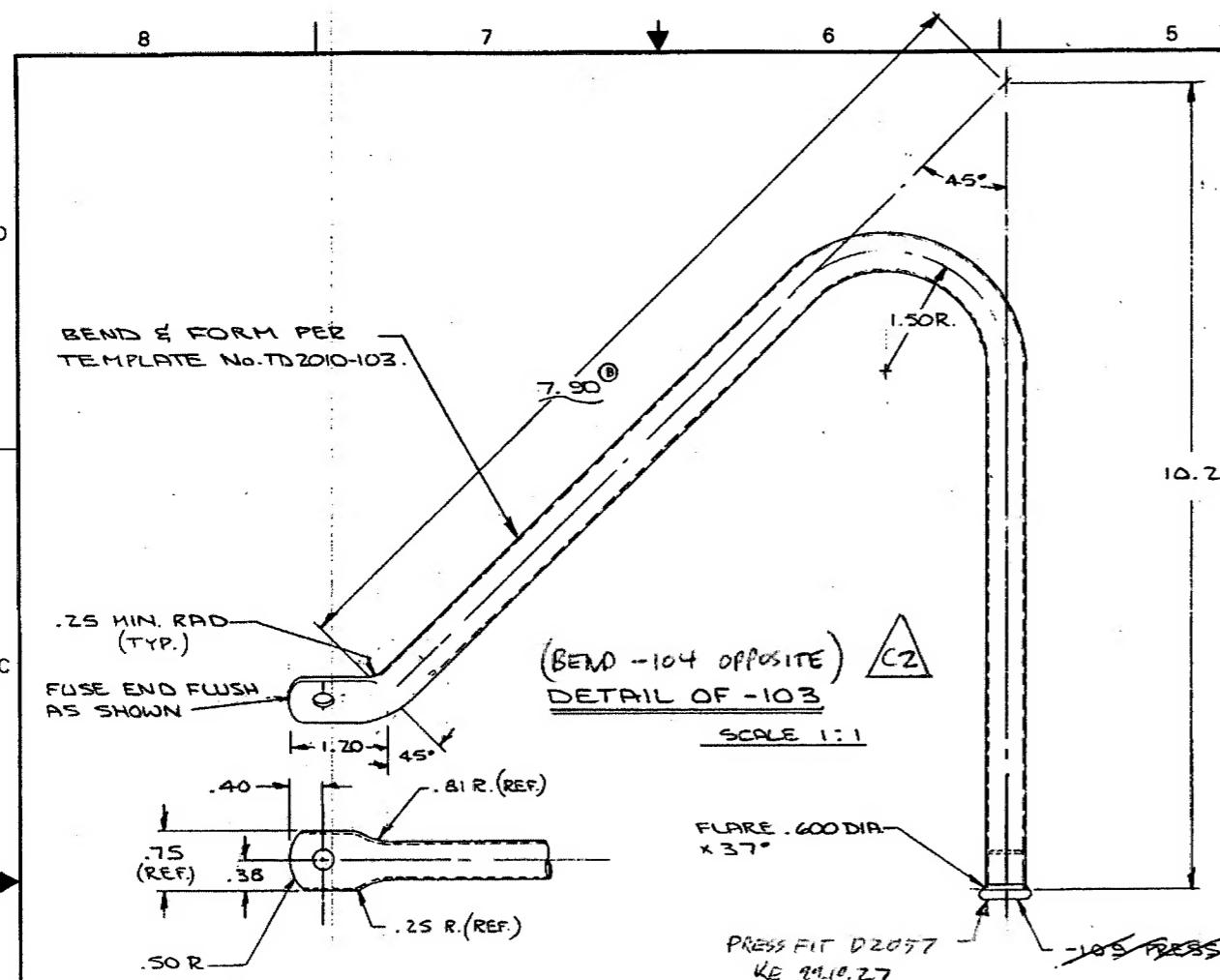
MF 08-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

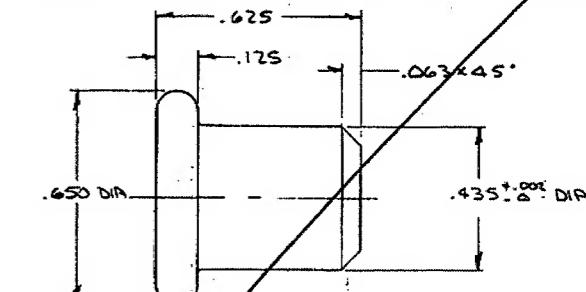
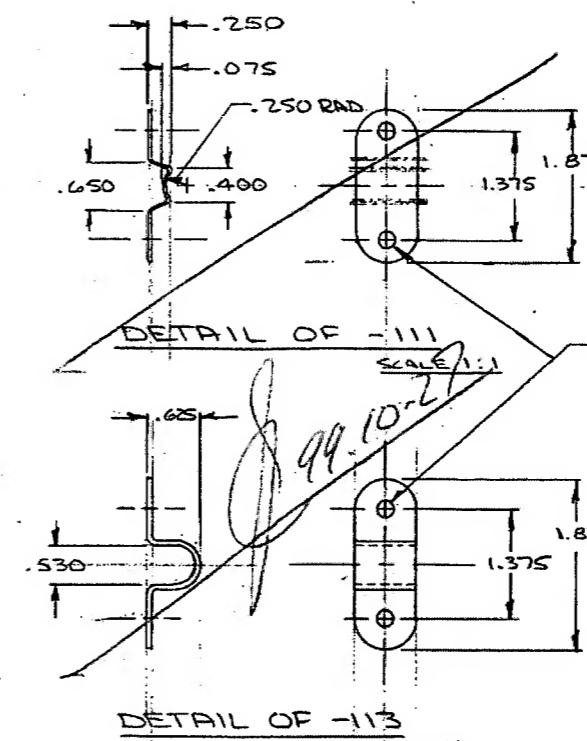
NOTE: Date & initial all entries



GENERAL NOTE

1. BEND RADIUS FOR 2024-T3
.063 THICK IS .188
 2. PAINT -101 MATTE BLACK.
 3. TYPE 304 STAINLESS STEEL MAY
BE SUBSTITUTED WITH TYPES
303 OR 316.
 4. 2024-T3 MAY BE SUBSTITUTED
WITH 2024-T3 CLAD (QQ-A-250/S)
 - 103 FINISH: POWDER COAT BLACK SANDTEX
(4.3.5.7) PER DART QSI 005 4.3 
 - FE-032-EF (QTY 4)

INSTALL PER PEM INSTALLATION
INSTRUCTIONS.



~~DETAIL OF -109~~ SCALE 4:1
Superseded by D2057 rev B
KLE 29.08.19 PRA/1229

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38773

RELEASED
04.02.03

4	FE-032-EF	FASTENER	PEM
D 2010-113	CLAMP	.050 THICK	ALSI 304
D 2010-111	SADDLE	.025 THICK	ALSI 304
I	D 2010-109	PLUG	6061-T6 BAR QQ-A-225/6
X	D 2010-103	ARM	CRES. TUBE .50 Dia x .035W ALSI 304
X	D 2010-101	BRACKET	2024-T3 .063 THK QQ-A-2504
F103-101 Y-RECD	PART NO.	ITEM	DESCRIPTION
			MATERIAL
			SPEC./VENDOR
APPROVAL	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA
DRAWN BRADLEY	DATE 90.03.31		
DESIGN BRADLEY	90.08.31		
STRESS			
CHECKED			
CLIENT			
TITLE MIRROR BRACKET DETAILS			
CODE		DWG NO.	D 2010
SCALE		NOTED	SHT 1 OF 1